



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5557-1

Job Sheet 188108



Part No: D5557-1

Job Qty: 12 ea

Part Name: Cutter Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/3/19

Job Tracking No:

Due Date: 1/18/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: TBD Dwg D5557 Rev.A7 IPP Rev.A New issue 18/01/29 JFS Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/18/19	1/18/19	0.00	0.00	Start Up Machining-4		mmr 19/01/19
110	CNC Vertical Machining	12 pcs	1/18/19	1/18/19	0.00	6.00	HAAS1-1		mmr 19/01/19
120	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC2 Machining-4		" "
130	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC8 Machining-4		BA 19-01-19
140	Outsource	12 pcs	1/18/19	1/18/19			MEI001-VC	10	CC 19-01-19
150	Packaging	12 pcs	1/18/19	1/18/19	0.00	0.00	Packaging2		DAS
155	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC6		38
160	SprayPaint	12 pcs	1/18/19	1/18/19	0.00	0.06	Spray Paint		AS 19-1-28
170	QC	12 pcs	1/18/19	1/18/19	0.00	0.00	QC14		PD 19-01-20
180	Packaging	12 pcs	1/18/19	1/18/19	0.00	0.00	Packaging3-2	CCC130	FEB 07 2019
190	QC21-SA	12 Ea	1/18/19	1/18/19	0.00	0.00	QC21	DAS 21	FEB 07 2019

Part Op 90 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB765 DWG REV: FOLIO REV: 2- Deburr and break all sharp edges EXCEPT OTHERWISE NOTED. SEE NOTE 8 ***KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE***

140 - PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED

160 - PRIME AS PER DWG AND QSI005, SEE NOTE #2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX*** PRIMER BATCH: S147812

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	4.6320 ft (.386 ea)	90-Start up Operation	S132658-4.74



Container No: S142980



Part: D5557-1

Job No: 188108

Serial No/Batch: S142980

Revision: PA7

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ations

Required	Inventory	Allocated
5	45	0

Plex 1/3/19 11:50 AM dart.lacelle.linda

Date: 01/09/19

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cutter Blade	1.030inches + 0.000 - 0.030	1.030 1.000	Product	
2	Cutter Blade	0.2500inches ± 0.0020	0.2520 0.2480		
3	Cutter Blade	0.5630inches ± 0.0100	0.5730 0.5530		
4	Cutter Blade	1.2000inches ± 0.0100	1.2100 1.1900		
5	Cutter Blade	0.1700inches + 0.0050 - 0.0010	0.1750 0.1690		
6	Cutter Blade	0.3400inches + 0.0000 - 0.0040	0.3400 0.3360		
7	Cutter Blade	0.2510inches ± 0.0100	0.2610 0.2410		
8	Cutter Blade	0.3380inches ± 0.0100	0.3480 0.3280		
9	Cutter Blade	4.5000inches ± 0.0300	4.5300 4.4700		
10	Cutter Blade	1.3000inches ± 0.0100	1.3100 1.2900		
11	Cutter Blade	3.2000inches ± 0.0100	3.2100 3.1900		
12	Cutter Blade	0.4900inches ± 0.0300	0.5200 0.4600		
13	Cutter Blade	0.7500inches ± 0.0100	0.7600 0.7400	Radius	
14	Cutter Blade	51.6000degrees ± 0.5000	52.1000 51.1000		
15	Cutter Blade	30.0000degrees ± 0.5000	30.5000 29.5000		

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Tel (613) 632-5200

PURCHASE ORDER

PO042253



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO042253
PO Date: 1/14/19
Due Date: 2/8/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188108	D5557-1	Cutter Blade : Various STC's PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed	-	2/8/19	12 pcs	0 pcs	12 pcs	\$10.125/pcs	\$121.50
2	187496	646.3014	Blade HEAT TREAT AS PER DWG, SEE NOTE #3	Firmed	-	2/8/19	20 pcs	0 pcs	20 pcs	\$10.125/pcs	\$202.50
Grand Total:											\$324.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
333349	1	133973

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
42253 ✓		A2	2019/1/15	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
32	D5557-1 ✓			7,
	(12) D5557-1 ✓			
	JOB 188108 ✓			
	(20) 646.3014 ✓			
	JOB 187496 ✓			
	1 BC EPS			

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	1	

CERTIFICAT
EMBALLER PCES SÉPARÉMENT

EXPÉDIÉ PAR: Shipped by:	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 32

POIDS EXPÉDIÉ / Weight Shipped : 7,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT
EMBALLER PCES SÉPARÉMENT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 32

POIDS EXPÉDIÉ / Weight Shipped : 7,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2019/01/21

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
333349	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42253 ✓	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	8	59 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
32	7	D5557-1 (12) D5557-1 ✓ JOB 188108 ✓ (20) 646.3014 ✓ JOB 187496 ✓ 1 BC EPS

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-01-20

Pierre Piché
Chief Inspector



APPROUVÉ

DAS
38
9-89